

Date: Thursday, 17/07/2008 12:31:13 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET
<b>Job Number</b> : 40589	
<b>Estimate Number</b> : 12812	
<b>P.O. Number</b> :	<b>Part Number</b> : D3610041
<b>This Issue</b> : 17/07/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3610 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 38301	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 01/08/2008 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JDOS 7.17</u>	
<b>Comment</b> : : est rev A    new issue    07.03.28    EC : est rev B    released, changed mat'l    EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4140NB1500X15000	4140 Steel Bar 1.50 x 1.50



**Comment:** Qty.: 0.5775 f(s)/Unit: Total: 6.9300 f(s)  
 AISI 4140 Steel Bar M106674

J.L 08/07/22

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blank 6.600 " long

J.L 08/07/22

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: A

2-Deburr per dwg D3610

MK 08/07/30

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MK 08/07/30

(12)

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SA 08/08/01

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3610-041 PAR #: N/A Fault Category: Prod / Mechanical NCR: Yes No DQA: D Date: 08/08/15  
 QA: N/C Closed: D Date: 08/08/15

NCR: <u>40589</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/07/15</u>	<u>3</u>	<u>the part too small of .110"</u> <u>R.C. the tool pullout of</u> <u>the holder.</u>	<u>[Signature]</u> <u>08/07/15</u>	<u>scrap and destroy</u> <u>replace Qty: 1</u> <u>Batch: <u>M106674</u></u>	<u>[Signature]</u> <u>08/07/30</u>	<u>[Signature]</u> <u>08/07/30</u>	<u>[Signature]</u> <u>08/07/30</u>	<u>[Signature]</u> <u>08/07/30</u>

NOTE: Date & initial all entries

Date: / Thursday, 17/07/2008 12:31:13 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40589

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-C'SINK AS PER DWG D3610

FF 08-08-12

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 12

8.0

POWDER COATING

POWDER COATING



M 106442



(12x)

Comment: POWDER COATING  
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00  
320 OF  
9:30

M-2 08/08/12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-12 12

10.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Nutplate  
Batch: M 108757

FF 08-08-14

11.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)  
RIVET  
batch: M 105978

FF 08-08-14

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Rivet Nut Plate as per Dwg D3610

FF 08-08-14

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BRACKET

Job Number: 40589

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



0608.14 (12)



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



(12)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 244A

8/8/14

SP

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

2008.08.15

Job Completion



11 08.08.15

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

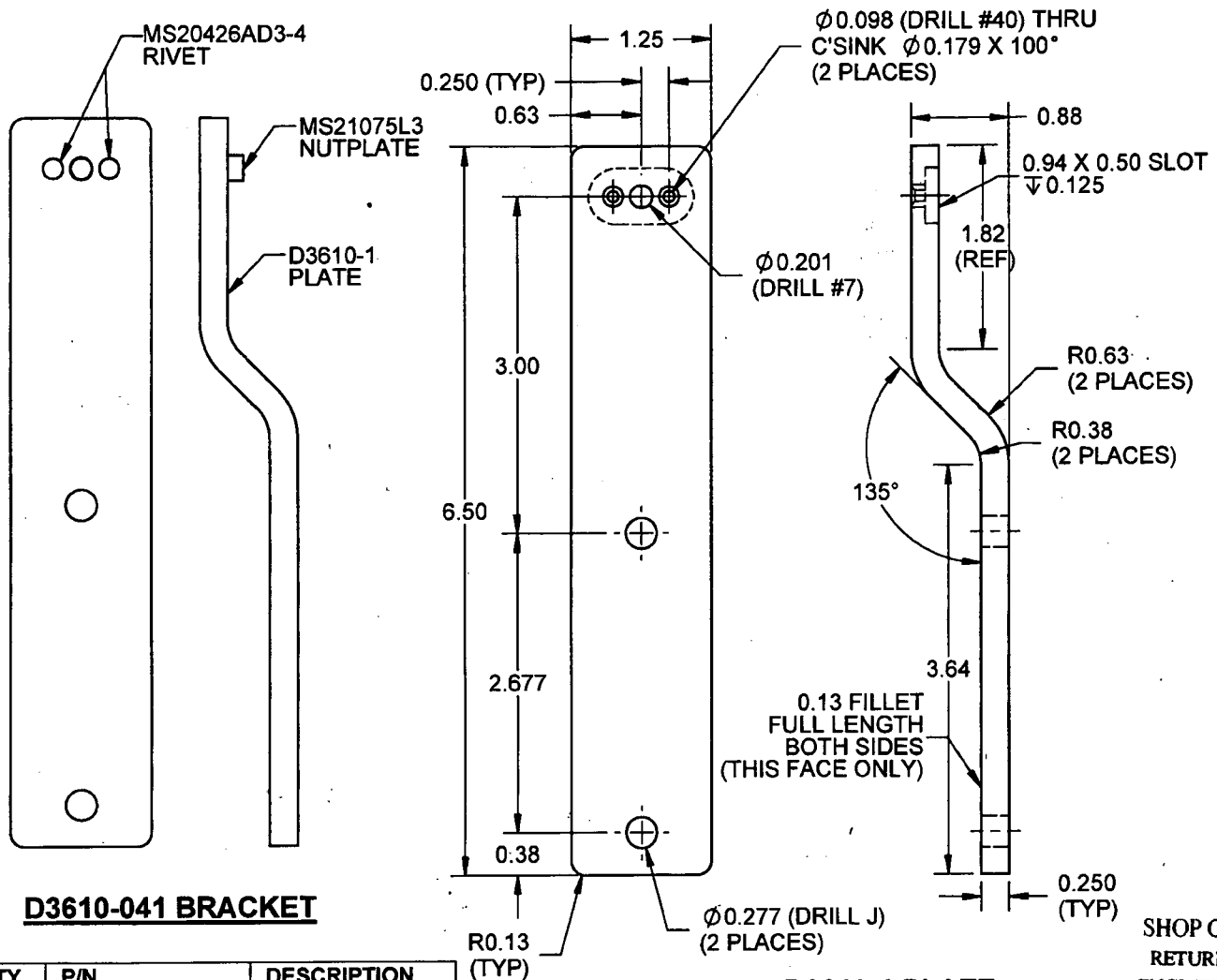
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3610</b>	REV. A SHEET 1 OF 1
DATE <b>07.04.20</b>	TITLE <b>BRACKET</b>		SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	

**D3610-041 BRACKET****D3610-1 PLATE**

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

**D3610-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

**D3610-1 NOTES:**

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

**RELEASED**

07.04.25

WORK ORDER

NO. 10589

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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